

WJS

4306
SHIP
~~77~~
8-24

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM720V6000102-3
Job Sheet 178214



Part No: RBEM720V6000102-3

Job Qty: 8 ea

Part Name: Front Sheet



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Created By: Logan David

Due Date: 6/18/18

Type: SOLD

Description:

Note: DWG RBEM720V6000102 Rev. 2 IPP Rev. A 18.05.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	8 Ea		6/18/18	0.00	0.00	Start Up Waterjet2		18/08/02
110	Waterjet	8 pcs		6/18/18	0.00	0.80	Waterjet 2 OMAX		18/08/02
120	QC	8 pcs		6/18/18	0.00	0.00	QC2 Waterjet-2		18/08/02
130	QC	8 pcs		6/18/18	0.00	0.00	QC8-6		18-08-09
140	Brake NC	8 pcs		6/18/18	0.00	0.80	Brake NC 1		18-08-09
150	QC	8 pcs		6/18/18	0.00	0.00	QC5		AUG 15 2018
160	Packaging	8 pcs		6/18/18	0.00	0.00	Packaging3		DAS 9-89
170	QC21-SA	8 Ea		6/18/18	0.00	0.00	QC21		21 AUG 17 2018

Part Op 100 -

Descriptions: 110 - 1-Cut as per Dwg Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary

140 - Form as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.063	5052-H32 .063 Sheet	15.8400 sf (1.98 ea)	100-Start up Operation	SOS 8002

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	M5052H32S.063	16	18	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 3:33 PM dart.logan.david



Container No: S098667



Part: RBEM720V6000102-3

Job No: 178214

Serial No/Batch: S098667

Revision: 2

Inspector:

Exp Date:

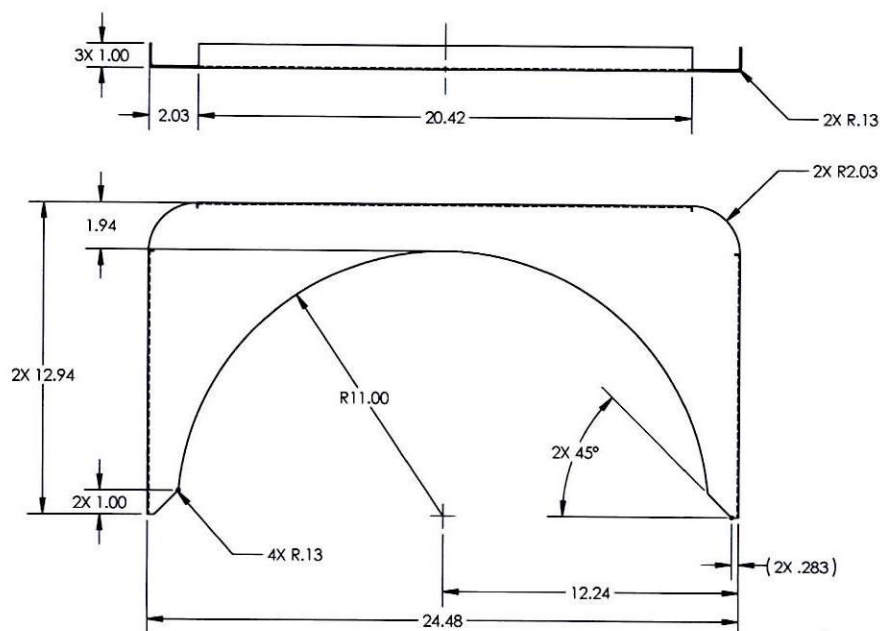
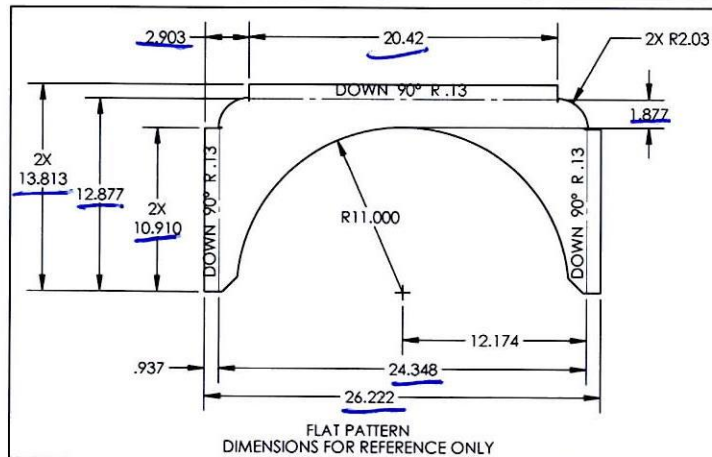
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/02/18

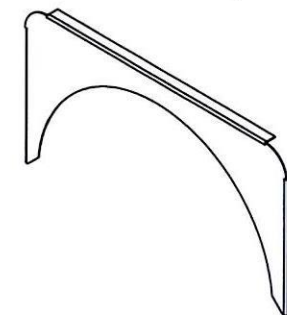
5105 21 01-1

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

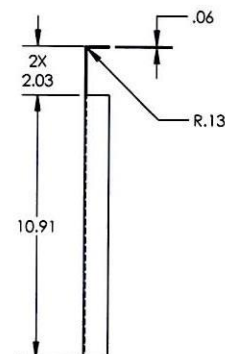


③
FRONT SHEET

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0217	-3 REDESIGNED TO BE WELDED. CHD DIMS WAS R10.65 IS 11.00, WAS 12.66 IS 12.94.	11/17/2016	RJC
				JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178244
20180712



DART AEROSPACE	
TITLE ENGINE BLANK	
DWG NO. RBEM720V6000102-3	
REV 2	
MATL: 5052 FINISH: SEE -1 SPEC:	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS & 1/8 .XX ± .03 ANGLES ±1° .X ± .1 SURFACES ±125 1. BREAK ALL SHARP EDGES .015 ± .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL H175
SCALE 1:5	DATE 11/10/2016 SHEET 3 OF 9

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																			
Description Work Order Deviation			Disposition																																																																				
			Completed By																																																																				
			Lead hand / Supervisor Approval Verification																																																																				
			QC / QA Coordinator Approval																																																																				
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		FAULT CATEGORY <table style="width:100%;"> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>			Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐																																																																					
Design ☐	Operator ☐	Bending ☐																																																																					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐																																																																					
Equip/Tooling ☐	Supplier ☐	Cracks ☐																																																																					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐																																																																					
Material ☐	Use for Testing ☐	Cuffs ☐																																																																					
Internal Transport ☐	Poor Information ☐	Crushing ☐																																																																					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																																																					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																																																					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																																																					
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																					
Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																					
BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																					
Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																					
Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																					
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																					
Countersink ☐	Off-set ☐	Drawing ☐																																																																					
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																					
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																					
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																					
			OTHER : _____																																																																				